

NCR-19-7689

011061



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Canada

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D5484-041
Job Sheet 193219



Part No: D5484-041

Job Qty: 12 pcs

Part Name: Aft Cap Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No: 13643

Due Date: 5/16/19

Created By: Dara Macdonald

Type: SOLD

Description:

Note: IPP REV:A 17.05.26 NEW ISSUE DD VERF:JFS IPP REV:B 17.11.03 AS PER DWG REV:A DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	12 pcs	5/16/19		0.00	3.00	Small Fab - 1		JUL 24 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	12 pcs	5/16/19		0.00	0.00	QC 5 - 10		JUL 24 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Handfinish - 1-1 Chemical-B4B	12 pcs	5/16/19		0.00	1.20	Handfinish - 1 - 1 - B4B		JUL 25 2019
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		

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1 - Charge for Qty 8 / →
2 - Close Open Ops

					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
135	QC 7	12 pcs	5/16/19	0.00 0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	BEB 19-07-25
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	

140 Small Fab - 2 - B4B	12 pcs	5/16/19	0.00 3.00	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	BEB19-07-25
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
150 QC 5	12 pcs	5/16/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
160 Powdercoat - 1 White GI(A)- B4B	12 pcs	5/16/19	0.00 3.00	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
START: 3:35 OUT: 3:00 FINISH: 4:05					
170 QC 3	12 pcs	5/16/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
180 Packaging 3-1 - Stock - B4B	12 pcs	5/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	

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JUL 25 2019

BK 19-7-05

JUL 19-7-24

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JUL 25 2019

BK 19-7-25

JUL 19-7-24

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				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FP-001 88 19-7-20
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	12 pcs	5/16/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	JUL 26 2019
				QC 21 - SA - 53	

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Part Op 100 - 1- Drill and C'sink rivet holes as per dwg Use DT10343 2- Deburr
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 120 - (Chemical Conversion Coat per QSI005 4.1)
 135 - (QC7-Inspect Chemical Conversion Coat)
 140 - Install nut plates as per dwg
 150 - (QC5- Inspect part completeness to step on W/O)
 160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum), ***HAND TIGHT A SCREW IN THE NUTPLATE PRIOR TO POWDERCOAT*** START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
 170 - QC3- Inspect Part Finish Standard Process
 180 - (Identify as per dwg & Stock Location: _____)
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
CCR264SS-3-04	Nutplate Rivet CCK004	48 Ea (4 ea)	100-Small Fab - 1	5162051
D5484-1	Aft Cap GA124	12 pcs (1 ea)	100-Small Fab - 1	3194527
MS21075L3N	Nut Plate ST248-6A02	24 Ea (2 ea)	100-Small Fab - 1	3041081

MS21075L3

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	CCR264SS-3-04	48	109	0
	D5484-1	12	35	0
	MS21075L3N	24	44	0

Part Specifications

Specifications could not be found.

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Container No: S200349



Part: D5484-041

Job No: 193219

Serial No/Batch: S200349

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/24/19

Entered:

Date:

28 Nov 1/19



NCR No.

14-7689

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job:

193219

DISPOSITION

Rework ☐Scrap ☒Use-as-is ☐Skid-tube ☐Machining ☐Large Fab ☐Cross tube ☐Small Fab ☒Finishing ☐Eng. (Non-AW) ☐Prod. Eng. Coord. ☐Rec/Store/Packaging ☐Engineering ☐Water Jet ☐Supplier ☐Quality ☐

Part No.

05484-041

Date:

JUL 24 2019

Sequence #:

110

QTY Affected:

40812 8

MRB (QSI042)

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51/9/10/21
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Completed By

40
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JUL 24 2019

Lead hand / Supervisor

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OCT 29 2019

QC / QA Coordinator

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Description Work Order Deviation

Holes where drilled offset to center which doesn't fit properly on the end of tube

Disposition

Scrap no replace

Root Cause

Operator ☒Manufacturing Process ☐Equip/Tooling ☒Handling/Preservation ☐Material ☐Product Improvement ☐Process Improvement ☐Human Factors ☐☐ Pressure/Forced☐ Bending☐ Crushing☐ Cracks☐ Crimp/Kink/Ripple/Wave/Twist☐ Marks/Chatter☐ Mislabeled

Other/Details:

☐ Contamination☐ Misaligned/off center☐ BOM/Route☐ Broken/Damage/Defect☐ Incomplete/Unclear Instructions☐ Drill Holes☒ Fit/Function

FAULT CATEGORY

☐ Power Loss/Surge☐ Folio/Program☐ Grain Direction☐ Weld☐ Wrong Stock Pulled☐ Out of Sequence☒ Off-set/Set-up☐ Positioned Wrong☐ Outside Tolerance☐ Drawing☐ Finish☐ Part Lost/Missing☐ Misread